

Work Order ID 64887

December 21, 2010 1:10:09 PM



Page 2

Item ID: D3195-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>cm 11/01/18</i>		<u>4</u>	<u>0</u>		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		<i>=> HU 11/01/18</i>		<u>4</u>	<u>0</u>		
150 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M112588</i> Memo START TIME: <i>8:35</i> <i>3:00</i> FINISH TIME: <i>9:05</i>	0.00 0.00				<u>4</u>	<u>0</u>		<i>BL H-01-19</i>

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Cust Item ID:

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



QC3- Inspect Part Finish

0.00

⇒ 11/01/19

QC

Memo

0.00

4

0

Quality Control

170



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Lightly Sand bonding surface □ 2-Bond D3195-7 into D3195-13as per Dwg
D3195 □ A/R Contact Cement M111095

11/01/19

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

11/01/19

74

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Setup Start



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Stop



Item Name: Bracket Assembly

Start Date: 12/21/10 Start Qty: 4.00



Cust Item ID:

Required Date: 12/30/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>246A</u>	0.00							
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/19/10

11/01/19

ME

11-01-19

Picklist Print

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Page 1

Work Order ID: 64887

Parent Item: D3195-043

Parent Item Name: Bracket Assembly



Start Date: 12/21/10

Required Date: 12/30/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-7  Pad		Manufactured	No			100	Each	8.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				8					
					64534			8		4			
M6061T6B1.500X01.25 0  6061-T6 Bar 1.50 x 1.25		Purchased	No			170	f	28.2560	0.3	1.263158			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT10				28.25595					
					107461			1.73315		1-3			
					110936			26.5228					

DART AEROSPACE LTD		Work Order: 64887
Description: Bracket		Part Number: D3195-3
Inspection Dwg: D3195	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.432	+/-0.010	3.432	✓		Vern 1-3	
1.265	+/-0.010	1.245	✓		"	
R0.37	+/-0.030	37	✓		"	
Ø0.277	+0.005/-0.000	278	✓		"	
2.677	+/-0.005	2.677	✓		"	
0.242	+/-0.010	238	✓		"	
0.377	+/-0.010	379	✓		"	
0.500	+/-0.010	502	✓		"	
R0.188	+/-0.010	188	✓		R-G	
0.250	+/-0.010	247	✓		"	
0.882	+/-0.010	880	✓		"	
1.250	+/-0.010	1.248	✓		"	
0.500	+/-0.010	500	✓		"	
Ø0.191	+0.005/-0.000	192	✓		"	
1.000	+/-0.010	1.000	✓		"	

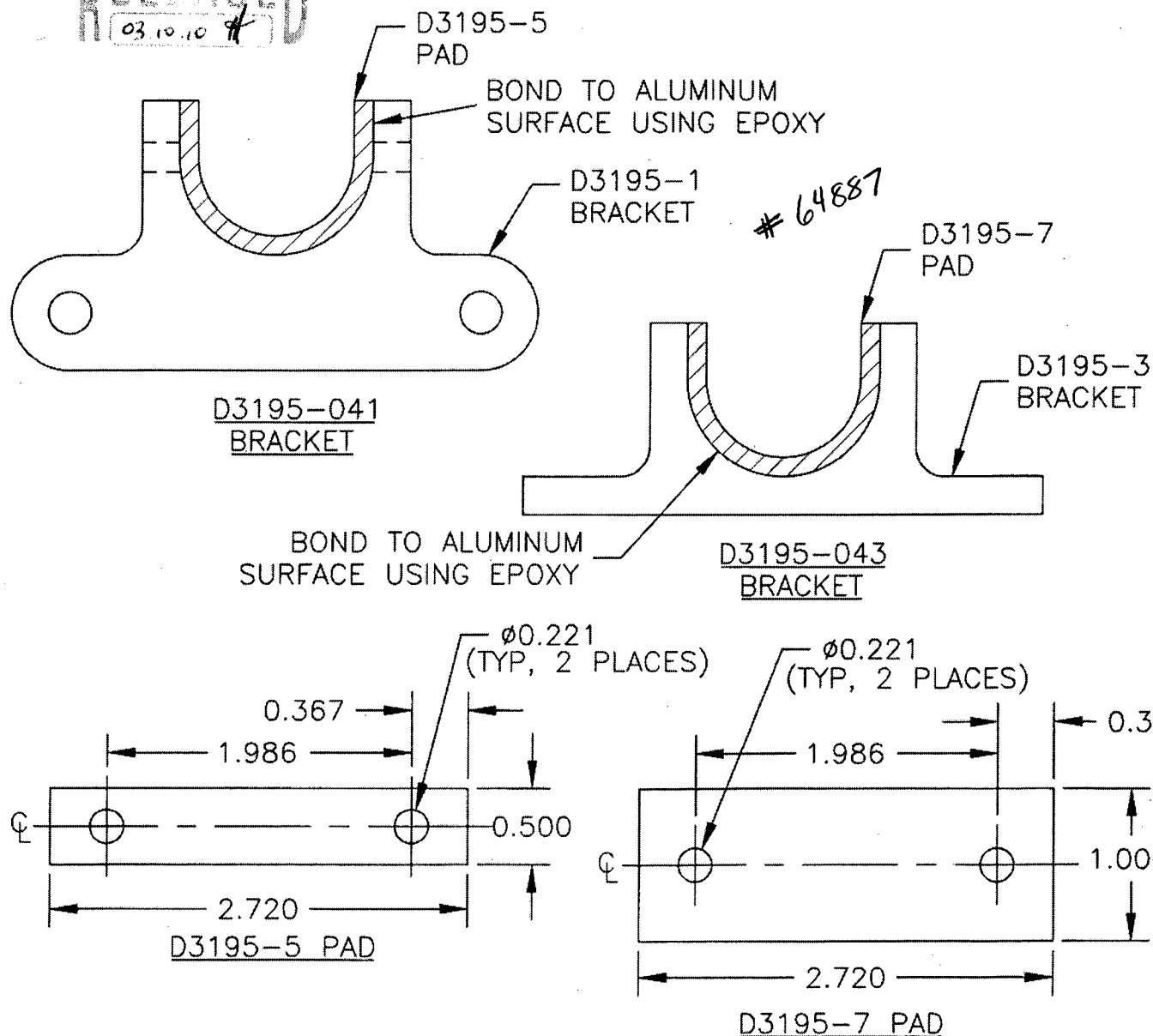
Measured by: SL	Audited by: [Signature]	Prototype Approval: N/A
Date: 11/01/18	Date: 11/01/18	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-013)	KJ/RF	
B	05.04.26	R0.37 was R0.037; 1.084 removed	KJ/JLM	[Signature]



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3195
				REV. A SHEET 1 OF 3
DATE	03.06.23	TITLE	BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE		

RELEASED
03.10.10 #



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

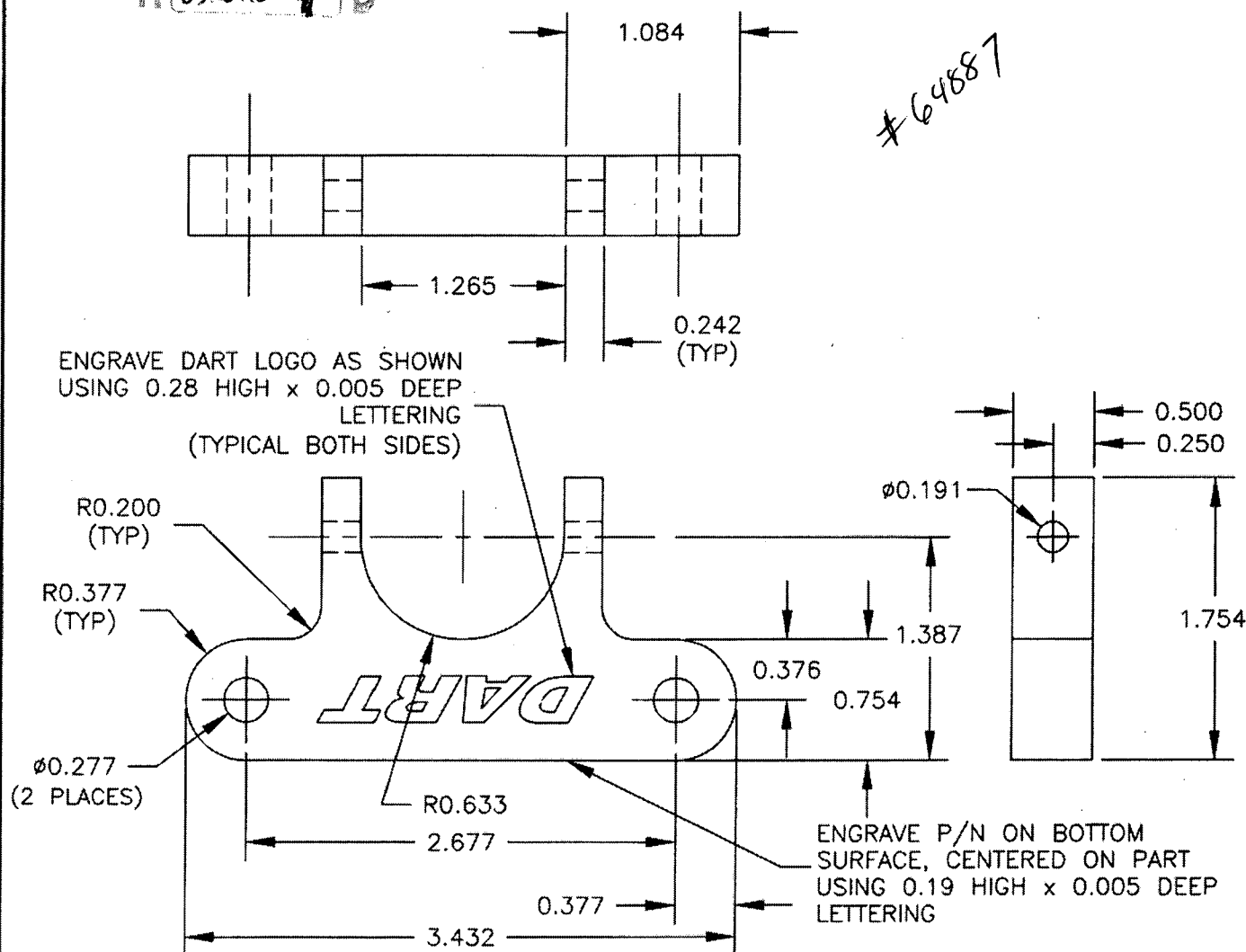
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

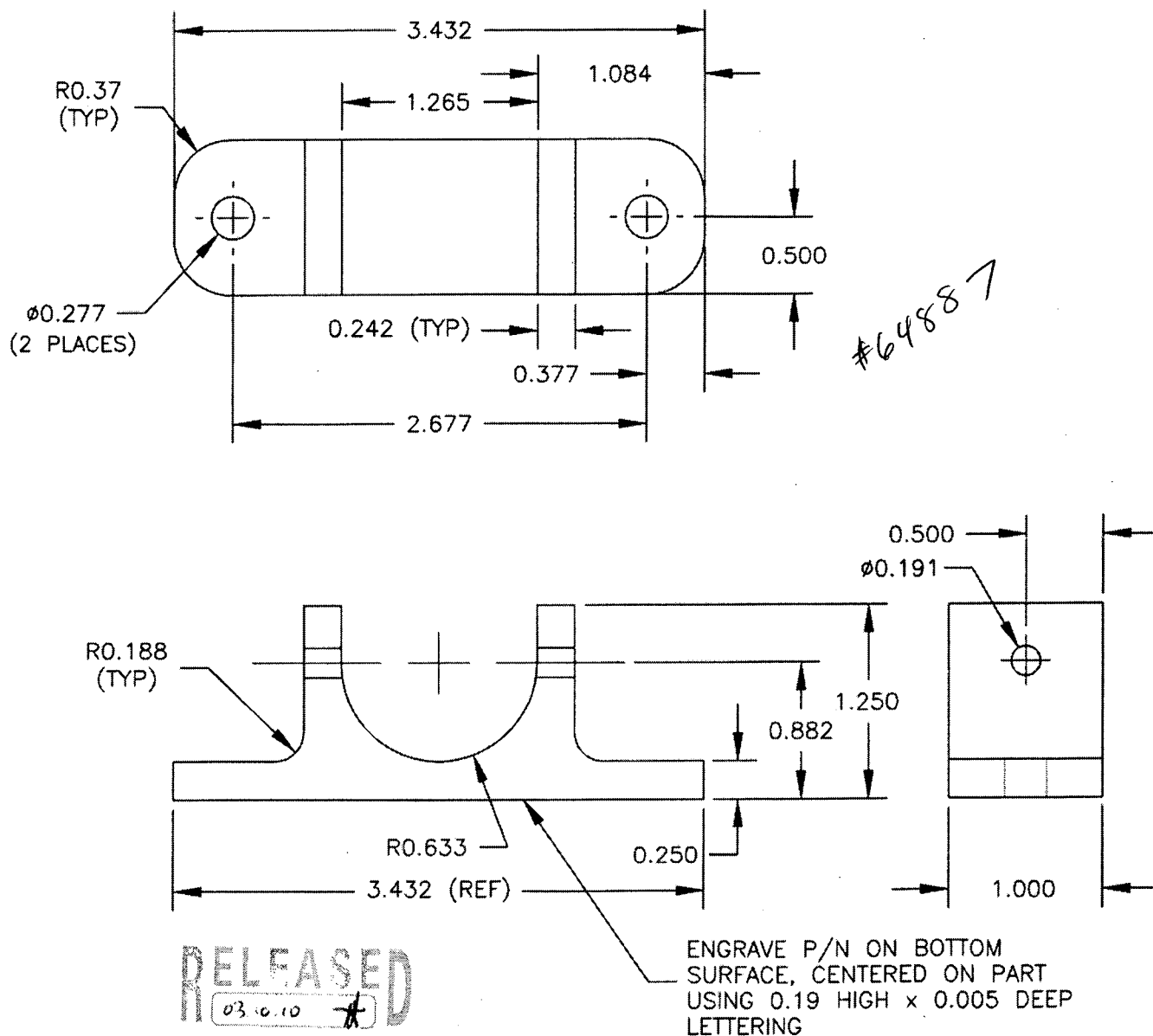
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3195
				REV. A SHEET 3 OF 3
DATE	03.06.23	TITLE	BRACKET	SCALE 1:1



RELEASED
03.0.10

D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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